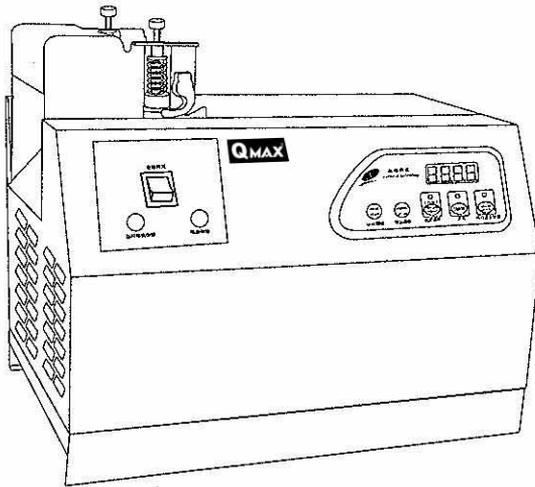


QMAX

Automatic Velcro-Tape Cutting Machine

User Manual



Model: FT-38C



velcro cutting
machine



unbox video



set length &
quantity
video



install cutter
module
video

AUTOMATIC BELT CUTTING MACHINE

Characteristic

Automatic machine cutting machine is a mechanical and electrical mechanical product. It can cut off all kinds of woven belts, magic plaster, plastic hose, shoelace, plastic zipper, plastic zipper, computer line, trademark and other materials according to the number of length you need. Different models have different additional functions.

Hot knives can heat sealing nylon weave belt, nylon trademark and other kinds of tape. Infrared positioning device can accurately locate and cut different kinds of trademarks through infrared sensing system, and have magic angle, chamfering angle and other angle devices.

It has the characteristics of high cutting precision, fast working speed, automatic stop work and simple operation. It is the best choice to improve *production* efficiency, product quality, save labor and enterprise profit.

Specifications

Cutting width: 1mm-160mm

Power: the rated power is 300W

Power supply voltage: AC voltage 200V-240V/50Hz

Matters needing attention

1. Please confirm that the power line is connected to the ground wire before use.
- 2, in order to ensure safety, do not close your hand or any object near the cutter during the cutting process.
- 3, when making any adjustment, please cut off the power supply to ensure safety.
- 4, apart from normal maintenance, please do not remove any spare parts at will.
- 5, the machine should be placed in a well ventilated, clean and dry place where there is no corrosive gas.
- 6, in case of high temperature weather, additional heat sink should be installed.
7. Use oil before using this machine.
- 8, insurance is not more than 5 A for fuse.
9. If there is any doubt about the operation and usage, please contact our company or local distributor. We will serve you wholeheartedly.



Operation method

1, the setting of the length:

According to length adjustment key, then a length set key, single digit flashing, and then according to the set key input number of digit, set after the number of digit, then a length adjustment key, ten digits flashing, and then set the number of ten digits, 100 bits, 1000 bits set with the same method. Note:(select the 1000 digit flash and press the set key once, then save the length.

2, the number of setting:

Select the number adjustment key setting, the same as the length setting. Note (when the 1000 digit flicker is selected, the number of keys is saved after pressing the set key).

3. The use of reposition:

When the length is set or the number is set, the length of the cutter is changed to 0 by pressing the reset button.

4. open the key: press the key to start or close the machine. Note (the length is 0 cannot start)

5. Mode setting of feeding motor

Turn off the power of the machine first, then press the display board to open the key, and then open the power switch, and then press the set key, display 0000 or 0255 according to the set key to set these two values, show 0000 to play the motor in the length of 100 to work, the length is larger than 100, not work, showing 0255 plays. The motor can work in any length. (this setting is mainly for cutting long material to automatically shut down the motor, and it is not necessary to use the motor when cutting long material, so as to improve the service life of the feeding motor).

6. Manual delivery

Press this button to make the feeding wheel run, and achieve the purpose of manual feeding.

Elimination of general fault

1. No power supply

- (1) check whether there is electricity to plug in the power supply
- (2) check whether the power fuse wire is disconnected

2. Cut or have the mouth.

- (1) properly adjust the guide screw of the guide rail.
- (2) use the manual knife adjustment function to align the upper and lower knives and maintain the level.

Note: if you do not maintain the level, you need to unscrew the screws to adjust the above treatment methods are not good, we must consider grinding or changing the knife.

3. The cut length and the set value are different

Each length is the same, but not the same as the set value, this is a normal phenomenon, because different materials have different elasticity, can reach the actual length by length compensation, such as the need to cut 115mm, set 115mm to start cutting, but cut out each actual length of 113mm, then by setting the length, such as setting, such as set. For 117mm or 118mm, and then cut the material to check whether it meets the actual length of 115mm.

4. The cutting length is unstable

- (1) adjust the speed of slow feed.
- (2) feeding wheel wear or synchronous pulley loosening, at this time to be adjusted or replaced.
- (3) if the computer control panel is subjected to electromagnetic interference, it is necessary to keep away from the source of interference.

5. The feed motor can be rotated but the knife is not cut

- (1) there are more dust on photoelectric sensor, so we must clean up the dust of photoelectric sensor.
- (2) the gear gear is worn and replaced at this time.
- (3) when the cutting motor is burned, it is necessary to change the belt motor.

AUTOMATIC BELT CUTTING MACHINE

6. The cutter can cut the motor without turning

- (1) the fuse of the feeding motor is burned, and the fuse should be replaced at this time. Note (fuse is not more than 5A)
- (2) the internal temperature of the machine is too high, and the driver of the thermostat protects the driver from working. At this point, it is necessary to turn off the machine and cool down or work in a low temperature environment.
- (3) a light blocking plate position change, adjust the light position, placed between the photoelectric sensors.
- (4) too much dust on the photoelectric sensor. Dust should be removed.

7, the whole machine does not start, the indicator lights are uniform, and there is alarm sound.

- (1) no material, at this time the material needs to be loaded.
- (2) the material is too thin. At this point, it is necessary to adjust the alarm screw without alarm, and then respond to the clockwise alarm until there is no alarm.

8, incisional deviation

- (1) the guide pipe position has not been adjusted well. At this time, the guide pipe must be re adjusted.
- (2) the material cut is not straight, and the cutting material needs to be replaced at this time.

9. The error of length is too large

- (1) the guide pipe position is too tight. At this time, the guide pipe position needs to be adjusted again.
- (2) the upper roller pressure is not enough, at this time need to adjust the upper roller pressure.
- (3) when the material is not loaded and the resistance is too high, it needs reloading at this time.

10. Stop and be irregular during the cutting process

The computer control panel is subjected to electromagnetic interference. At this point, turn off the power and restart.

11. The power switch is bright but the display board is no power

- (1) the temperature protector is bad, and it should be replaced at this time.
- (2) the main circuit board is bad, it should be replaced at this time.
- (3) the computer display board is bad, it should be replaced at this time.

12. The material will stick a knife

- (1) the temperature is not high enough, and the temperature needs to be raised at this time.
- (2) the unloading steel wire has not been adjusted well, so the position of the unloading steel wire needs to be adjusted until the knife is not sticky.
- (3) the deformation of the unloading steel wire needs to be rectified or replaced at this time.

13. Display board display ----A

The fault is that the cutter is timeout and the restarting knife will not move.

- (1) the cutter part has a large resistance. It can be lubricated with oil and manually turn down the cutter motor.
- (2) fault of gear transmission mechanism.
- (3) the line and mouth contact of the PCB is not good.

The reopening knife can cut, but not feed the possible reason: the position of the photoelectric sensor deformation, loose two fixed screws, slowly upward or downward adjustment, side tune, until so far.

14. Display board display ----B

This failure is the fault of photoelectric sensor.

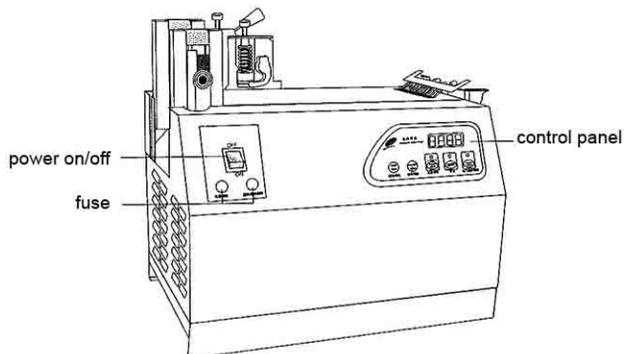
- (1) there is too much dust on the photoelectric sensor.
- (2) damage (replacement) of photoelectric sensor.

15. Display board display ----C

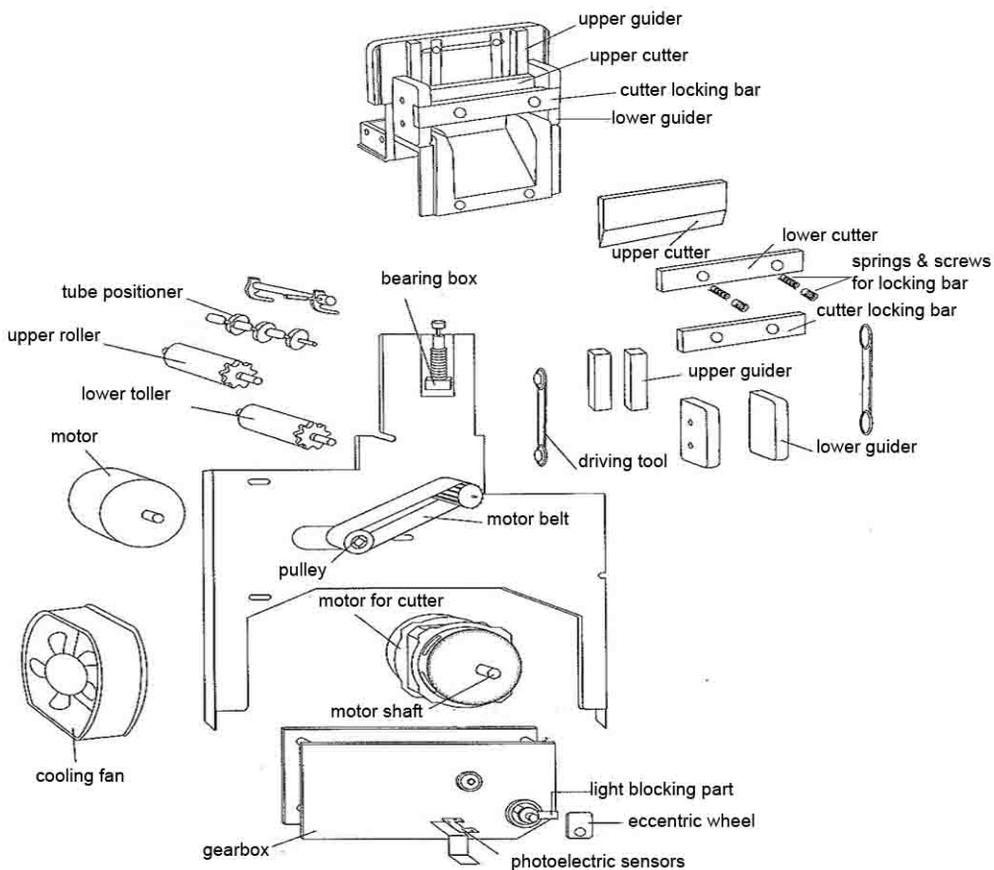
This kind of fault is too poor to locate.

If you turn on the machine for a few times, it is possible that the contact of the circuit board is not good. (it is recommended to reinsert all plug lines)
 If such a possible reason arises occasionally, the braking time can be increased by reducing the magnetic force of the motor. Press and hold the length adjustment key not to put, and open the power switch at the same time, the display board shows the number of brake parameters (range from 0.65 to 0.50), can be added to the original value of 20 so slowly try (as far as possible not to adjust too large, the General Assembly influence stability and motor heat), such as the number of display is 95, plus 20 to 115, and then the length adjustment key to each one flashing, the data is saved, (the best look at the data is not saved, close the machine and hold the length key, and open the power, the display board should show 0115, if not to re operate, until save) again. Turn off the machine to start, if it will appear again, add 20 best not to exceed 200, so that debugging can generally be normal! If not, it may be the motor running capacitor problem, to be replaced!

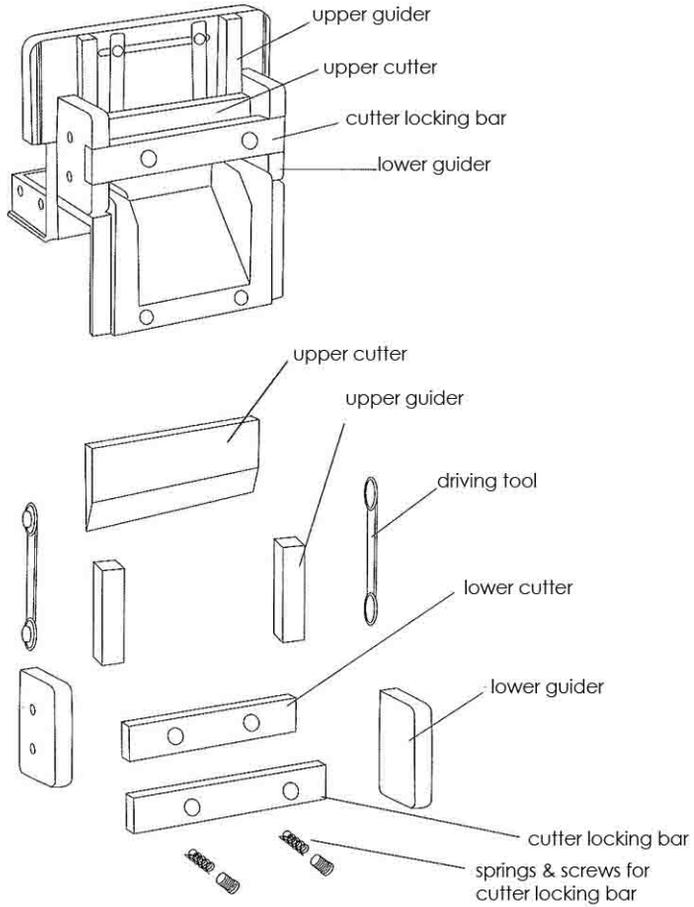
Machine Parts Description



Parts Description of Standard Cutter



Parts Description of standard cutter



Settings

Instructions in Chinese

操作方法

长度设定

①  0000 按动“长度调整”键一次，进入个位设定状态，此时数码显示中个位“0”不断闪烁。	③  0000 个位数字设定后，再按动“长度调整”键一次，进入十位设定状态，此时数码显示中十位“0”不断闪烁。	⑤  0000 十位数字设定后，再按动“长度调整”键一次，进入百位设定状态，此时数码显示中百位“0”不断闪烁。	⑦  0000 百位数字设定后，再按动“长度调整”键一次，进入千位设定状态，此时数码显示中千位“0”不断闪烁。
②  000! 按动“设定”键，开始设置个位所需的数字。	④  00!0 按动“设定”键，开始设置十位所需的数字。	⑥  0!00 按动“设定”键，开始设置百位所需的数字。	⑧  !000 按动“设定”键，开始设置千位所需的数字。

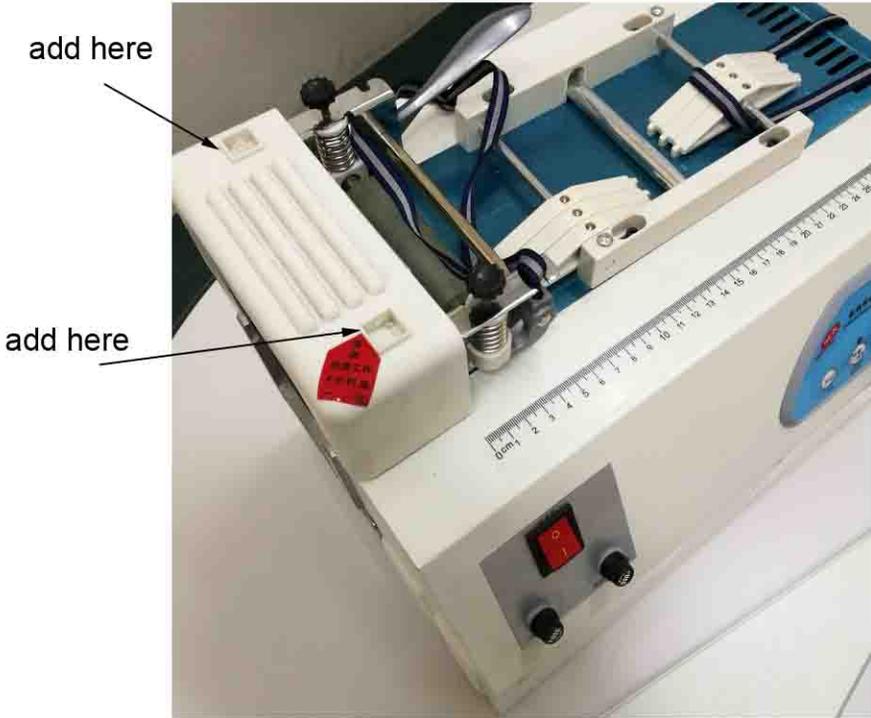
Length & Quantity Setup Procedure

1. Press C [length adjust], 1st digit will blink. Press C again to select 2nd digit to adjust. Press A [settings] to select the length of the velcro tape. For example, if the length is 50mm, then the display will show 0050.
2. After selecting the length, press B [amount adjust] to input the number of pieces to be cut. For example, if 100 pieces are to be cut, the display will show 0100.
3. When both length and quantity is set, just press D [on/off] to start the machine cutting.
4. To input new data, press E [reset]. Then, input the new data.

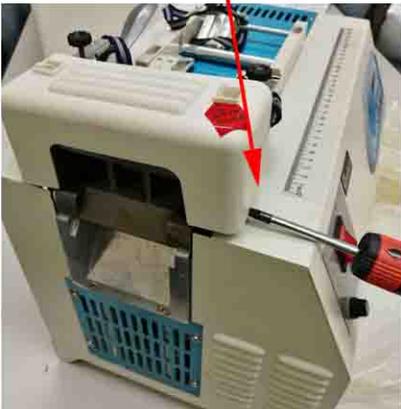


Adding lubricating oil

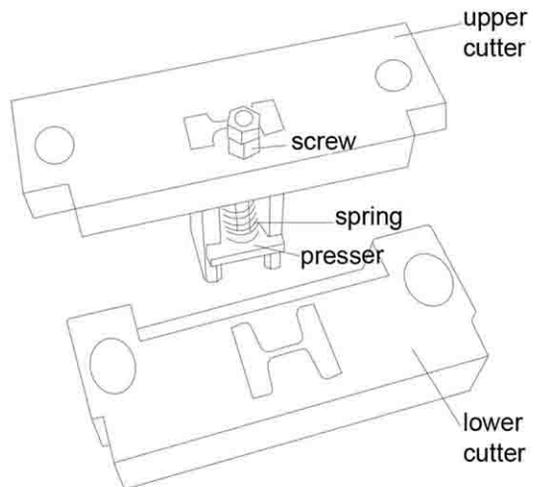
every 4 hours to the moving parts



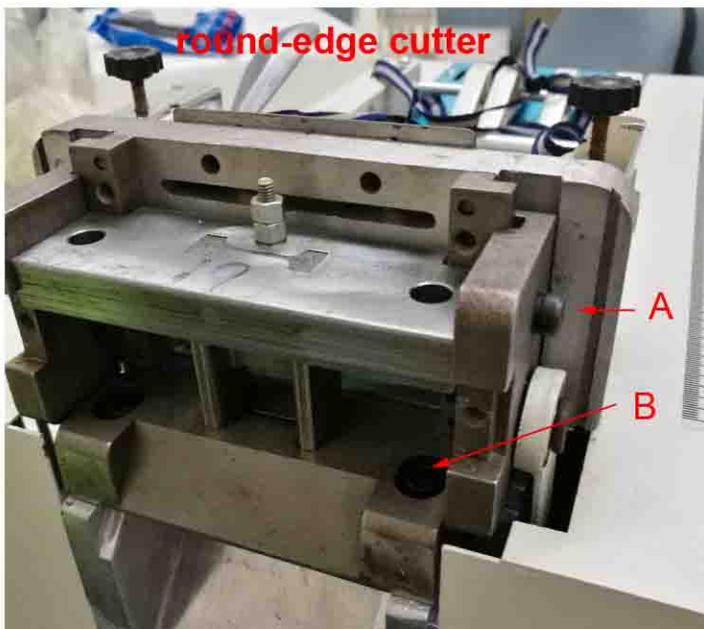
Lifting up the plastic cover with a screwdriver to access to the cutter



Round-Edge Cutter Module



Cutter Spare parts



ELECTRIC SAFETY NOTICE

To prevent fire or shock hazard, do not expose the unit to rain or moisture. To avoid electrical shock, do not open the control box or front panel. Refer servicing to qualified personnel only.

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